

Date: Friday, 01/02/2008 8:56:50 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : OUTBOARD WINDOW DOUBLER  
 Job Number : 37134  
 Estimate Number : 13148  
 P.O. Number :  
 This Issue : 01/02/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : SMALL /MED FAB  
 Previous Run :  
 Written By :                       
 Checked & Approved By :                       
 Comment : Est Rev:A 08-01-30 new issue DD verified by:

Part Number : D37003  
 Drawing Number : D3700 *U/R prototype*  
 Project Number : N/A  
 Drawing Revision : U/R  
 Material :  
 Due Date : 08/02/2008 Qty: 2 Um: Each

**PROTOTYPE**

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S080 6061-T6 .080 Sheet



Comment: Qty.: 0.1746 sf(s)/Unit Total: 0.3492 sf(s)  
 6061T6 aluminium sheet .080" thick  
 (M6061T6S080)  
 Batch: 106320 IB 8-1-2

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3700 U/R IB 8-1-2  
 Dwg Rev: U/R  
 Prog Rev: U/R  
 2- Deburr if necessary IB 8-1-2

②

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr if necessary

IB 08-02-20

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 01/02/2008 8:56:51 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTBOARD WINDOW DOUBLER

Job Number: 37134

Part Number: D37003

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP

**ENGINEERING  
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*Bob 02-20*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*N/A*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*Bob 02-20*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Bob 05/21*

Job Completion



*mf 08-05-16*

**FOR ENGINEERING USE ONLY**

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# PROTOTYPE REQUEST FORM

DART Aerospace Ltd.



Product #: D412-761

Job #: 00224A

Date: 08.01.31

Product Name: VERTICAL REFERENCE DOOR

Requested By: MB

Design Manager Approval: [Signature]

Quantity	Part Number	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
2	D3700-1	INBOARD WINDOW DOUBLER	08.01.29	YES	ASAP	SEE BELOW	
2	D3700-3	OUTBOARD WINDOW DOUBLER	08.01.29	YES	ASAP	SEE BELOW	
2	D3701-1F	(FLOOR DOUBLER) FLAT PATTERN	08.01.29	YES	ASAP	SEE BELOW	
2	D3702-1	FORWARD DOUBLER	08.01.30	YES	ASAP	MAKE ONE WITH HOLES/SLOT + ONE WITHOUT HOLES/SLOT + SEE BELOW.	
2	D3703-1	AFT DOUBLER	08.01.30	YES	ASAP	SEE BELOW	
						HAND ALL W/Os AND PARTS TO DAN STOW	

D

C

B

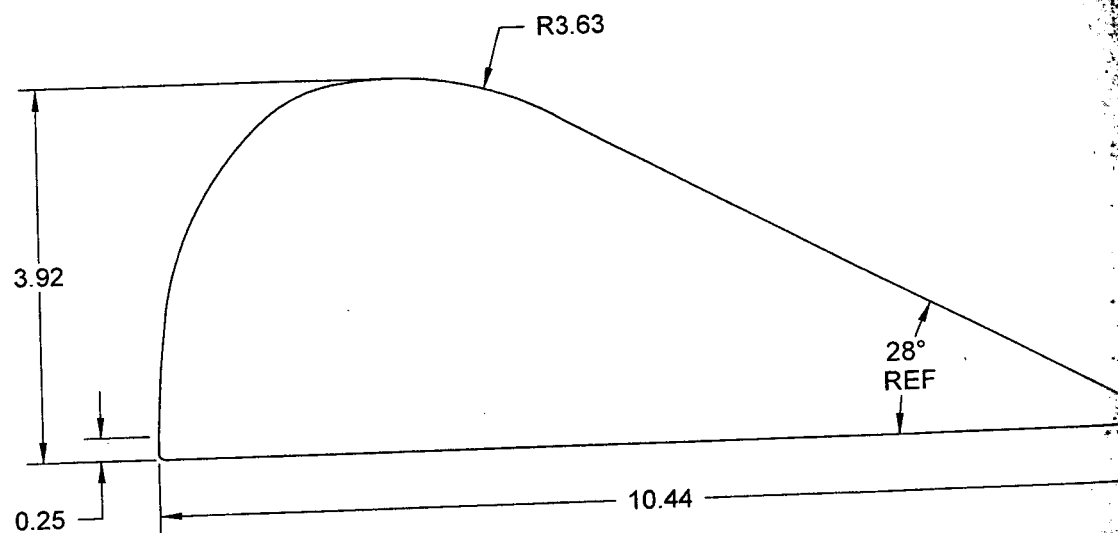
A

8

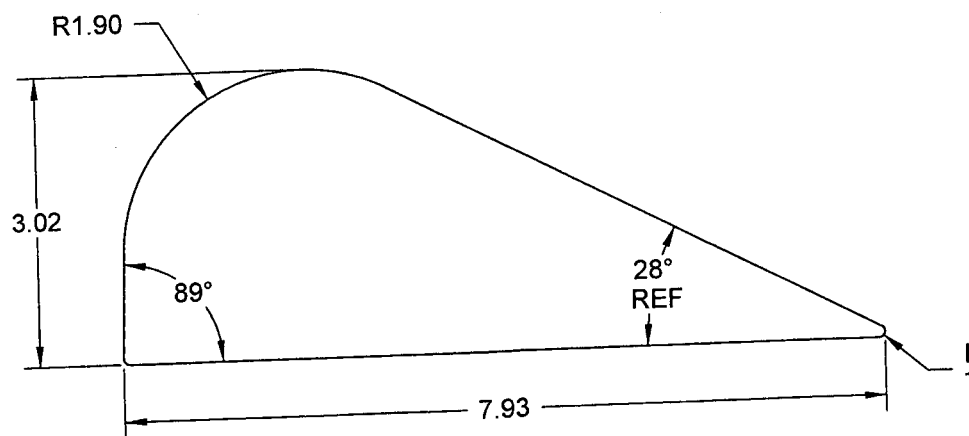
7

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5



**D3700-1 INBOARD WINDOW DOUBLER**



**D3700-3 OUTBOARD WINDOW DOUBLER**

7

6

5

4

3

2

1

D

C

B

R0.06  
TYP

**PRELIMINARY ISSUE**

08-01-29

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. A
MFG. APPR.		D3700	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WINDOW DOUBLER	1:2
DATE	08.01.29	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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1

0.06  
YP

